



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2370-1
Job Sheet 166529



Part No: D2370-1

Job Qty: 1 ea

Part Name: Litter Frame Assembly



Part Weight: 0 lbs

Status: Production

Priority: Medium

Job Created: 10/1/17

Job Tracking No:

Due Date: 10/31/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV D IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D2370-1 Litter Frame Assembly	DWG REV D IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS		0.000	
D2374 Stud	DWG REV A IPP D 03.04.04 Reformat; Made on Cobra KJ/RF IPP Rev:E Now on Doosan Lathe 08-05-05 JLM Verified By:EC		0.000	
D2378 Bolt	DWG REV A IPP: B 99.05.10 Re-format DM		0.000	
D2484 Locknut	DWG REV A IPP A 00.03.02 New Issue EC		0.000	
NAS1149D0416J Washer			0.000	
D2370-1P Litter Frame Assembly			0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
100	Purchasing	1 pcs	10/30/17	0.00	0.00	Purchasing	
130	Small Fab	1 pcs	10/31/17	0.00	0.93	Small Fab	
140	QC	1 pcs	10/31/17	0.00	0.00	QC5	
150	Packaging	1 pcs	10/31/17	0.00	0.00	Packaging3	
160	QC21-SA	1 Ea	10/31/17	0.00	0.00	QC21	

Part Op 100 - Issue p/o: _____ Order: Model 12-2A undrilled with grey pad & black belts Su
Descriptions: compliance required
130 - 1- Assemble D2374 STUDS WITH HARDWARE as per Dwg D2370 2-Assemble d237
140 - Check for loose rivet and ensure fit of D4812-041
150 - LOCATION :ST208

Job BOM

Part / Item	Component Name	Quantity	Operation
D2370-1 B166529		1 Ea (1 ea)	100-Purchasing
D2374	Stud	4 Ea (4 ea)	130-Small Fab
D2378	Bolt	4 Ea (4 ea)	130-Small Fab
D2484	Locknut	4 Ea (4 ea)	130-Small Fab
NAS1149D0416J	Washer	4 Ea (4 ea)	130-Small Fab

Job Allocations

Status: Stock

Part: **D2370-1 B166529**

Created: 9/30/17 11:46 AM DART.MICHAUD-
FEBRILLE.VICTORIA



Serial No: **S000069**

Printed By: Goldston, Justin 10/2/17 10:44 AM



Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Litter Frame Assembly

PART NO: D2370-1

Revision:

Operation: Small Fab

Quantity: 1

Change No:

Mfg Date: 10/18/17

Job No: 166529

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	D2370-1 B166529	1	1	0	0
130-Small Fab	D2374	4	0	0	0
	D2378	4	0	0	0
	D2484	4	0	0	0
	NAS1149D0416J	4	0	0	0
Part Specifications					
Specifications could not be found.					

Plex 10/1/17 2:34 PM Dart.Baker.Diane

Work Order Summary

Thursday, September 28, 2017 10:46:10 AM

Page 1 of 1

Criteria : Work Order ID: 166529 Item ID: D2370-1 Product Family SMALL FAB
Work Order Start Dates 9/27/2017 to 9/27/2017 11:59:59 PM Work Order Required Dates 10/6/2017 to 10/6/2017 11:59:59 PM
All References
Work Order Status Released

Work Order ID 166529 Required Qty 1.0000 Status Code Released
Item ID D2370-1 Accepted Qty 0.0000 Scrap Qty 0.0000
Item Name Litter Frame Assembly
Current Acct Value \$1,940.365

Start Date 9/27/2017 Required Date 10/6/2017 Completed Date

Standard ** Actual ** ** Acct. Value ** ** Variance ** ** Variance % **

Direct Costs	Total	Each	Each	Each	Each
Material	\$1,782.000	\$0.000	\$1,801.092	\$1,801.092	100.00%
Labor	\$0.000	\$0.000	\$36.217	\$36.217	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$0.000	\$0.000	\$103.056	\$103.056	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$1,782.000	\$0.000	\$1,940.365	\$1,940.365	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
D2370-1P Litter Frame Assembly	1.0000		9/27/2017	1.0000	\$1,782.000
Total Matl Amts:					\$1,782.000

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 166529

166529

Page 1

Wednesday, September 27, 2017 7:45:19 AM

Item ID: D2370-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Litter Frame Assembly
 Start Date: 9/27/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/6/2017 Req'd Qty: 1.00 *1* Customer:

Reference: DAS 13 9-29
 Approvals: Process Plan: Date: SEP 27 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2370	REV D								
100	PURCHASING	0.00							SEP 27 2017 DAS 13 9-29
100									
Purchasing	Memo	0.00							
Purchasing	Issue p/o: 36849								
	Order: Model 12-2A undrilled with grey pad & black belts								
	Supplier: Ferno Aviation								
	Letter of compliance required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.01							
Packaging	Insure that letter of compliance is attached to w/o								
120	QC6- All purchased or subcontracted products	0.00							
120									
QC	Memo	0.00							
Quality Control									SEP 28 2017 DAS 38 9-29

1x SP 17 9-27.

Work Order ID 166529***166529***

Page 2

Wednesday, September 27, 2017 7:45:19 AM

Item ID: D2370-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Litter Frame Assembly
Start Date: 9/27/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/6/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- Assemble D2374 STUDS WITH HARDWARE as per Dwg D2370 2-Assemble d2379 belt as per dwg								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.02							
Quality Control	Check for loose rivet and ensure fit of D4812-041								
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.01							
Packaging	LOCATION :ST208								

166529

Wednesday, September 27, 2017 7:45:19 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/27/2017 **Start Qty:** 1.00 ***1***

Required Date: 10/6/2017 **Req'd Qty:** 1.00 *** 1 ***

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.10

Quality Control

- Wednesday, September 27, 2017 7:45:18 AM

Work Order ID: 166529

Parent Item: D2370-1

Parent Item Name: Litter Frame Assembly

Start Date: 9/27/2017

Required Date: 10/6/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2370-1P *D2370-1P* Litter Frame Assembly		Purchased	No			100	Each	0.0000	1	1			
D2374 *D2374* Stud		Manufactured	No			130	Each	11.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST006		11							
				163814		11							
D2378 *D2378* Bolt		Manufactured	No			130	Each	18.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST007		18							
				163997		18							
D2484 *D2484* Locknut		Manufactured	No			130	Each	37.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		37							
				158094		3							
				161472		4							
				163252		30							

Picklist Print

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Wednesday, September 27, 2017 7:45:18 AM

166500
D2370-1

Parent Item: D2370-1

Parent Item Name: Litter Frame Assembly

Start Date: 9/27/2017

Required Date: 10/6/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0416J

Purchased

No

130

Each

3,278.000

4

4

NAS1149D0416.I

WASHER

Location

Loc Qty

Loc Code

GA

566

m131511

566

ST264

2712

m131511

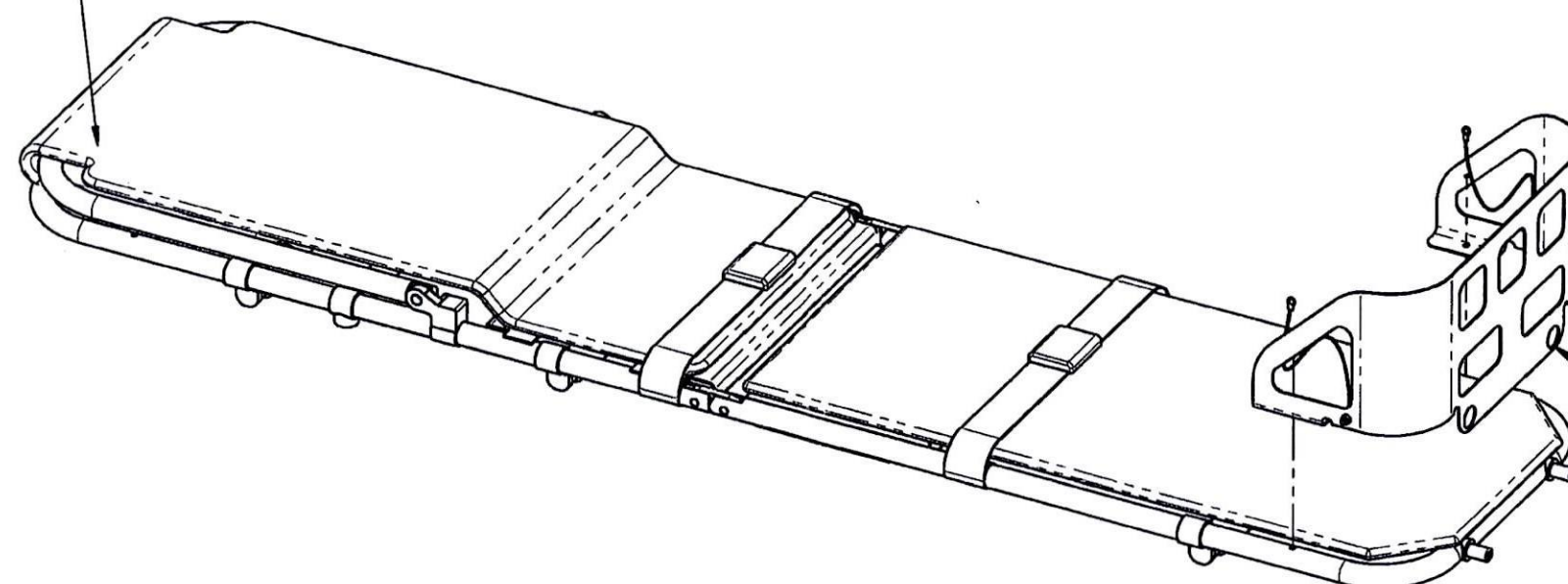
2712

ITEM	QTY -041	P/N	DESCRIPTION
	X	D2370-041	LITTER ASSEMBLY
1	1	D2370-1	LITTER FRAME ASSY
2	1	D4812-041	PATIENT STOP ASSY

D2370-1 LITTER FRAME ASSEMBLY

SEP 27 2017
DAS
13
9-89

W/O: 146529



D4812-041 PATIENT STOP ASSY

POSITION PATIENT STOP OVER
FWD STUDS AND SECURE
WITH PIP PINS

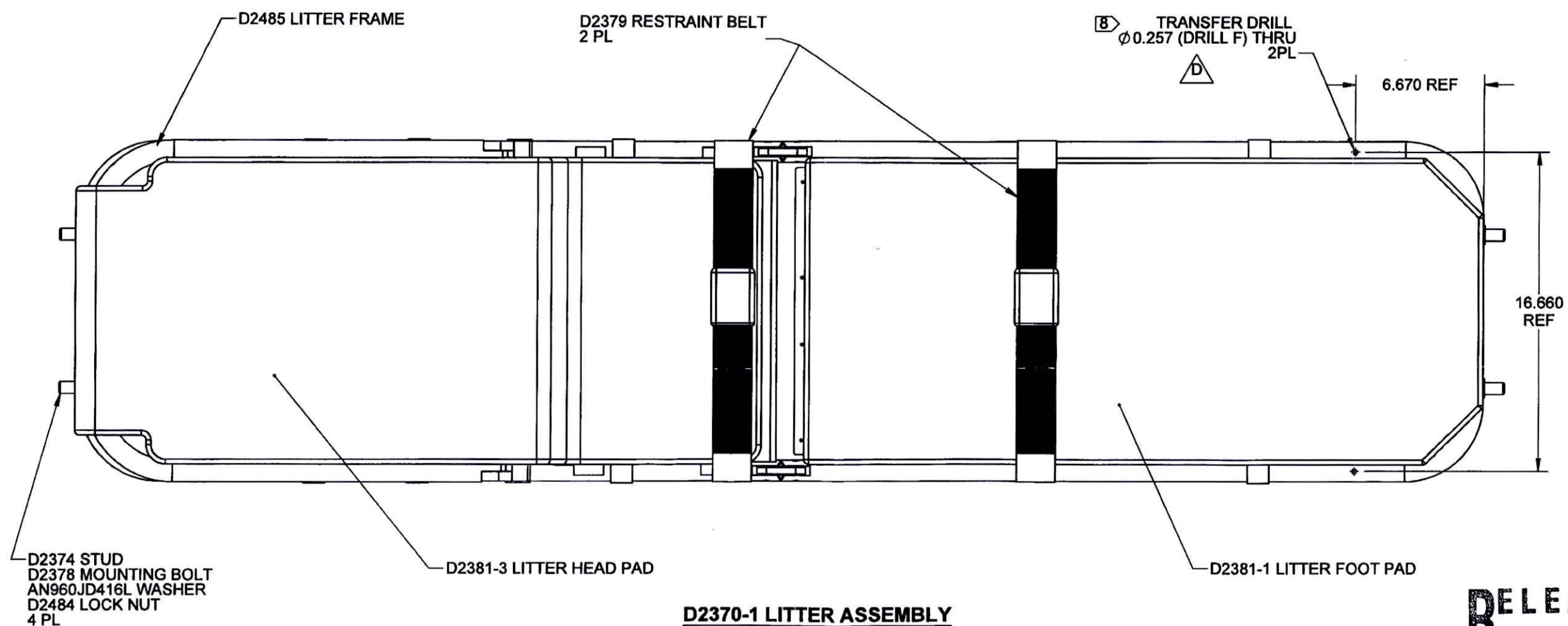
D2370-041 LITTER ASSEMBLY

RELEASED
2013-05-16
MD

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 25.73 Lbs

D	Ø0.257 HOLES WERE Ø0.191 HOLES, 2PL (ZN C3-2), CREATED -1 AND -041 ASSEMBLIES, NEW DWG FORMAT	DB	13.03.27
C	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES AND 5.00 WAS 5.34	KE	06.11.21
B	ADDED Ø0.191 HOLES	KE	98.06.09
A	NEW ISSUE	NA	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	4/1	D2370	SHEET 1 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	LITTER ASSEMBLY	NTS
DATE	13.03.27	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -1	P/N	DESCRIPTION
	X	D2370-1	LITTER ASSEMBLY
1	4	D2374	STUD
2	4	D2378	MOUNTING BOLT
3	2	D2379	RESTRAINT BELT
4	1	D2381-1	LITTER FOOT PAD
5	1	D2381-3	LITTER HEAD PAD
6	4	D2484	LOCK NUT
7	1	D2485	LITTER FRAME
8	4	AN960JD416L	WASHER



D2370-1 LITTER ASSEMBLY

RELEASED
2013-05-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2370-1" USING A REMOVABLE TAG AS PER QS1 044 METHOD 6.6
- 7) WEIGHT: 24.69 Lbs
- 8) TRANSFER DRILL USING D4812-041 AS TEMPLATE. ENSURE FIT AND REMOVE FOR SHIPPING

DESIGN	DB	DART AEROSPACE LTD
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA
CHECKED	A.P.	DRAWING NO. D2370
MFG. APPR.	2/	REV. D
APPROVED	2/	SHEET 2 OF 2
DE APPR.	2/	TITLE LITTER ASSEMBLY
DATE	13.03.27	SCALE NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO36849

Purchase Order Date 6/28/2017 7:36:10 AM

PO Print Date 9/27/2017

Page Number 1 of 3

Order From : VU-FER001
FERNO AVIATION INC.
735-B BRANCH DR.
ALPHARETTA,, GA 30004
US

Ship To : DART AEROSPACE LTD
1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name
Vendor Phone 770 521 1005
Vendor Fax 770 521 0910
Ship To Contact
Ship To Phone
Ship Method FedEx Economy collect
Ship Acct

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB EXW - (Ex Works)

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
----------	---	------------------------	----------------------	---------	-------------------

8	D2370-1P	Litter Frame Assembly	9/27/2017 Yes 9/27/2017	1.00 Each	\$1,782.00
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AS PER DWG D2370 REV. D
B166530
MODEL 12-2A UNDRILLED WITH GREY PAD & BLACK BELTS

Line Total: \$1,782.00

9	D2370-1P	Litter Frame Assembly	9/27/2017 Yes 9/27/2017	1.00 Each	\$1,782.00
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AS PER DWG D2370 REV. D
B166529
MODEL 12-2A UNDRILLED WITH GREY PAD & BLACK BELTS

DA: 38
9-89

SP 179-27

Line Total: \$1,782.00

PO Instructions: Fedex Acc#151793240

9/27/2017

FERNO Aviation, INC.

735B Branch Drive
Alpharetta, GA 30004

Packing Slip

DATE	PACKING SLIP NO.
9/22/2017	18305

BILL TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Attn: Accounts Payable

SHIP TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Ref: PO36849

P.O. NUMBER	TERMS	REP	SHIP DATE	SHIP VIA	FOB	
PO36849	Net 30	CW	9/22/2017	FedEx Economy	Alpharetta, GA	
ITEM	DESCRIPTION				QTY ORD.	QTY DEL.
12-2A (DART)	12-2A Litter Assembly W/Gray FAA Approved cover/pad assy. and Black FAA approved patient restraints (HS Code 8803.30.00.00), Serial # 17N372723, 17N372724, 17N372725, 17N372726 Notes: 1. Ship Collect via FedEx Economy on Acct # 151793240 <i>1x SPT-9-27</i>				4	4

0A\$
38
3.80



P 937.382.1451
F 937.382.1191

70 Weil Way
Wilmington, Ohio 45177

877.733.0911
www.ferno.com

4 August, 2017

Certificate of Conformance

Supplier: Ferno-Washington Inc.

Supplier Address: 70 Weil Way
Wilmington, Ohio 45177 USA
937-382-1451

Order No. 213369

Reference P.O. Ferno Aviation PO#: 10573
Dart PO# PO36849

Model No. Model 12-2 Emergency Stretcher

Item Number: Ferno-Washington #
0163255 12-2 STRETCHER GRAY

Ferno Catalog Number: N/A

Serial Nos. 17N372719, 17N372720, 17N372721, 17N372722, 17N372723,
17N372724, 17N372725, 17N372726, 17N372727, 17N372728

I certify that the above referenced products are produced in accordance with applicable Ferno-Washington Inc. quality standards using approved manufacturing methods and materials. The products have been inspected using approved test procedures and inspection criteria for Ferno-Washington medical devices.

Ferno-Washington Inc. is a registered manufacturer (Registration No. 1523574) with the United States Food and Drug Administration (FDA) as a manufacturer of medical devices, the Quality Management System is in compliance to the FDA's Code of Federal Regulations 21 CFR Part 820.

Ferno-Washington, Inc. also maintains a Quality Management System that fulfills the requirements of ISO 9001:2008 and ISO 13485:2003. Copies of Ferno-Washington, Inc.'s ISO 9001 and ISO 13485 certificates issued by Intertek are available upon request.

Shawn Fitzgerald
Director of Quality